

Date: Wednesday, 3/21/2007 3:48:38 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 31420	
Estimate Number : 12786	
P.O. Number : <u>N/A</u>	Part Number : D35645
This Issue : 3/21/2007 S.O. No. :	Drawing Number : D3564 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 31136	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 3/30/2007 Qty: 10 Um: Each
Checked & Approved By : <u>[Signature] 07.03.22</u>	
Comment : Est Rev:A New Issue 07-03-08 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 1.1099 sf(s)/Unit Total : 11.0985 sf(s)
 M304S16GA Stainless steel sheet 0.063" thick
 Batch: H101873

SAD 07/03/24

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3564
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

SAD 07/03/24

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/03/24

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 07/03/24

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Deburr if necessary
 Form on Brake as per Dwg D3564 using Jigs DT and DT
 Form Joggle as per Dwg D3564 on brake using Jig DT

MF 07-03-30 - (10)
 SB 07/04/02 (10)
 LCM 07/03/29 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/05

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/21/2007 3:48:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 31420

Part Number: D35645

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



20704.02



Comment: INSPECT WORK TO CURRENT STEP
Ensure joggle as per dwg D3429

7.0

POWDER COATING

POWDER COATING



M/01601



Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FD

07/04/03

(18)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/04/04 (18)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

07/04/04 (18)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/05 (10)

Job Completion



U 07/04/04

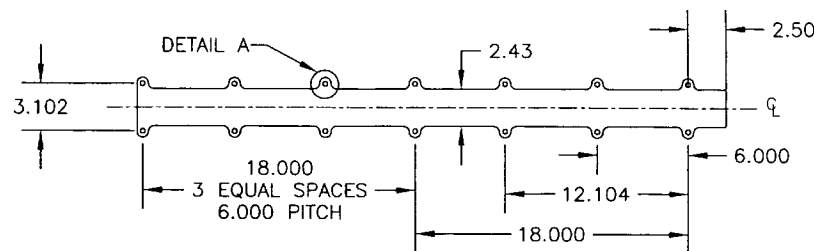
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

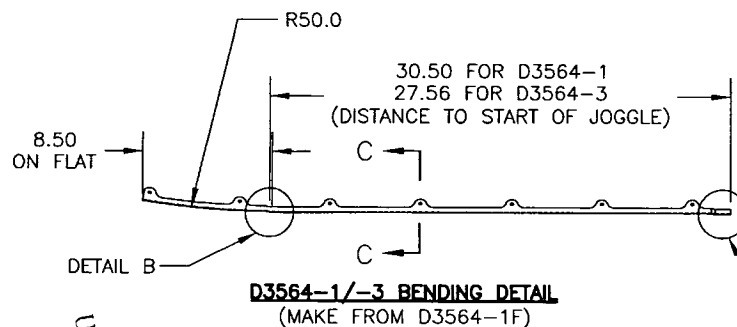
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

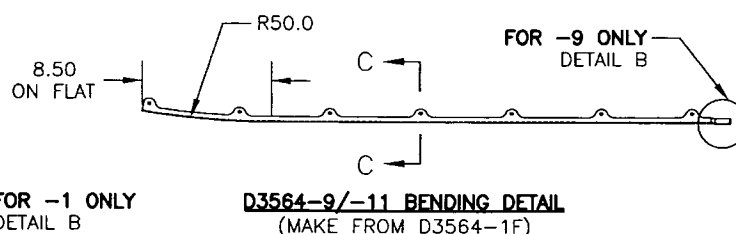
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN

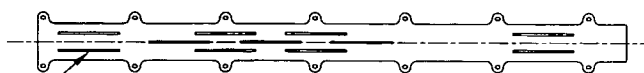


D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D3564-1/-3/-9/-11 WELDING DETAIL

NO. 31420
WORK ORDER
SUBJECT TO ATTACHMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

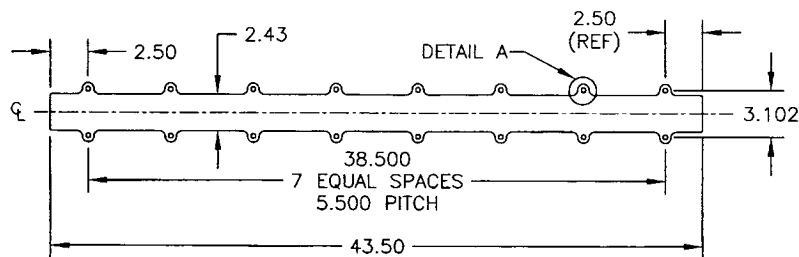
RELEASED

07.07.28

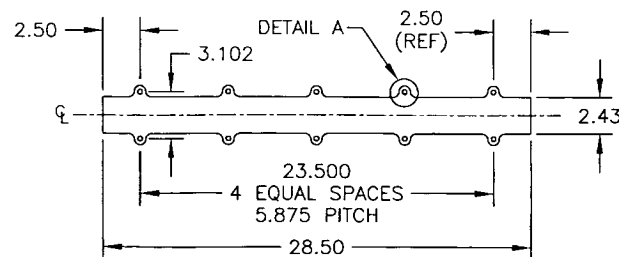
D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

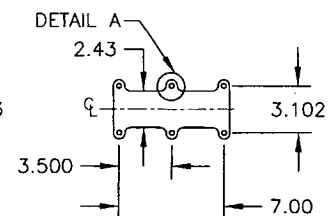
A		06.12.18	NEW ISSUE
DESIGN	PH	DRAWN BY	PH
CHECKED	PH	APPROVED	PH
DATE		06.12.18	
COPYRIGHT © 2006 BY DART AEROSPACE LTD.		DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		DRAWING NO. D3564	REV. A SHEET 1 OF 2
		TITLE	WEARSHOE
		SCALE	1:8



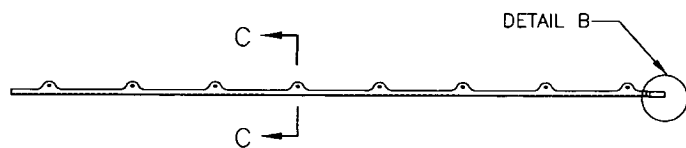
D3564-5F FLAT PATTERN



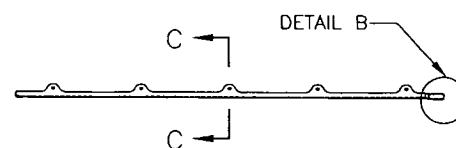
D3564-7F FLAT PATTERN



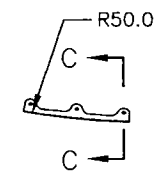
D3564-13F FLAT PATTERN



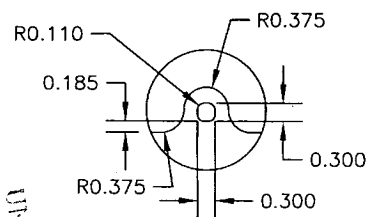
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



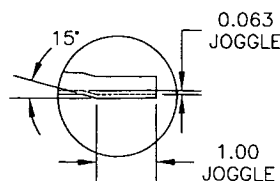
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



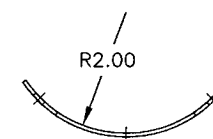
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



DETAIL A
SCALE 1:2



DETAIL B
SCALE 1:2



SECTION C-C
SCALE 1:2

RELEASED
07 02 28

NO. 31420
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
SUBJECT TO ATTENDANT

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DESIGN RH	DRAWN BY RH	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D3564	REV. A SHEET 2 OF 2
DATE 06.12.18	TITLE WEARSHOE	SCALE 1:8	

DART AEROSPACE LTD		Work Order: 31420
Description: Wearplate wear shoe		Part Number: D35645
Inspection Dwg: D35645 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

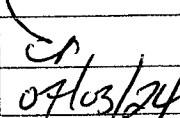


First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 43.50	± 0.030	43.50	✓		M-T/Vern	
B 5.500 (pitch)	± 0.010	5.495	✓		Vern	
C 3.102	± 0.010	3.099	✓		Vern	
D 2.50	± 0.030	2.50	✓		Vern	
E 2.43	± 0.030	2.43	✓		Vern	
F 2.50	± 0.030	2.498	✓		Vern	
G 0.300	± 0.010	0.307	✓		Vern	
H 0.300	± 0.010	0.303	✓		Vern	
I 0.063	± 0.010	0.068	✓		Vern	
J R0.375	± 0.010	R0.375	✓		R-G	
K R0.110	± 0.010	R0.110	✓		R-G	
L						
M						
N						
O						
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Q						
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T						
U						
V						
W						
X						
Y						

Measured by: SAD	Audited by: 	Prototype Approval:	N/A
Date: 07/03/24	Date: 07/03/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	